

Date: Friday, 29/05/2009 3:48:26 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 48300B		
Estimate Number	: 10207		
P.O. Number	:	Part Number	: D2989043
This Issue	: 29/05/2009 S.O. No. :	Drawing Number	: D2989 REVD
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 29/05/2009 Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 48299B	Material	:
Written By	:	Due Date	: 08/06/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>2009.05.29</u>		
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D29893	Rib
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B 44770</u> → 1x <u>29/06/02</u>	
✓ 2.0	D29894	Rib
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B 44769</u> → 1x <u>29/06/02</u>	
✓ 3.0	D29895	Rib
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B 46304</u> → 2x <u>29/06/02</u>	
✓ 4.0	D22211	Rib
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B 47952</u> → 1x <u>29/06/02</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
✓ 5.0	D31821 	Hinge
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Hinge batch: <u>B345504</u> → 2x <i>SY 09/06/02</i>		
✓ 6.0	D34423 	Shim
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Shim batch: <u>B 45607</u> → 2x <i>SY 09/06/02</i>		
✓ 7.0	D3827041 	Rib Assembly (Inboard)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Rib Assembly (Inboard) batch: <u>B 46476</u> → 1x <i>SY 09/06/02</i>		
✓ 8.0	D38325 	Mesh (Lid)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Mesh (Lid) batch: <u>46307</u> <i>SY 09/06/02</i>		
✓ 9.0	D38335 	Mesh (Lid End)
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Mesh (Lid End) batch: <u>B44767</u> → 2x <i>SY 09/06/02</i>		
✓ 10.0	D3838041 	Rib Assembly (Basket Lid, LH)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Rib Assembly (Basket Lid, LH) batch: <u>B 44772</u> → 1x <i>SY 09/06/02</i>		
✓ 11.0	D3838042 	Rib Assembly (Basket Lid, RH)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Rib Assembly (Basket Lid, RH) batch: <u>B 44773</u> → 1x <i>SY 09/06/02</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 - 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 - 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
- A/R ER316 S.S. Rod Batch: 4109213

SL 09/06/02

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-06-08

14.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/06/08 @

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

- 1- Plug holes prior to powder coating
- 2- Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: 8:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:30am

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 8:40am

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:10am

SL 09-06-09 (X)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

BR 09-06-09 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/11
MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

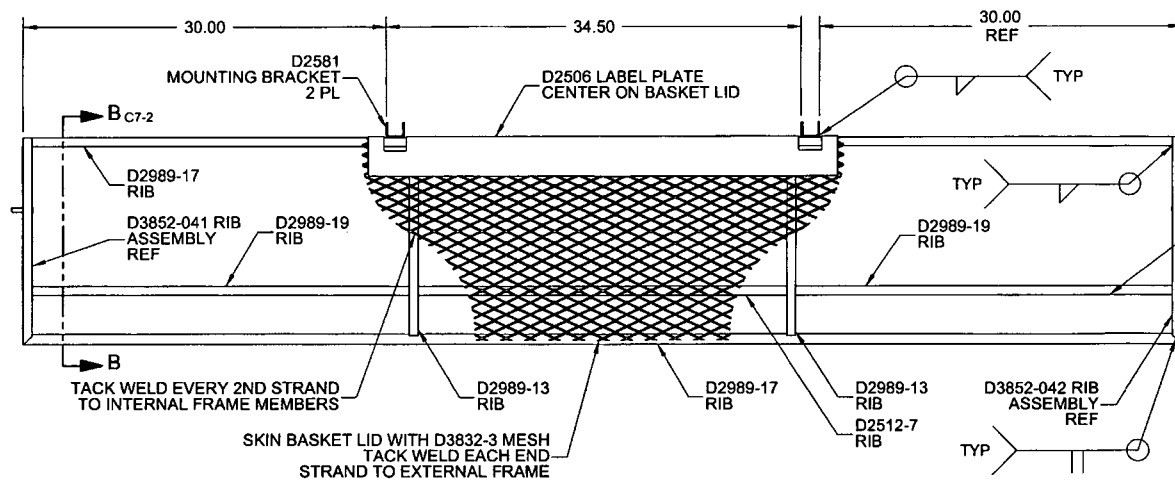
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

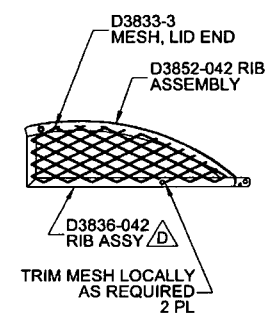
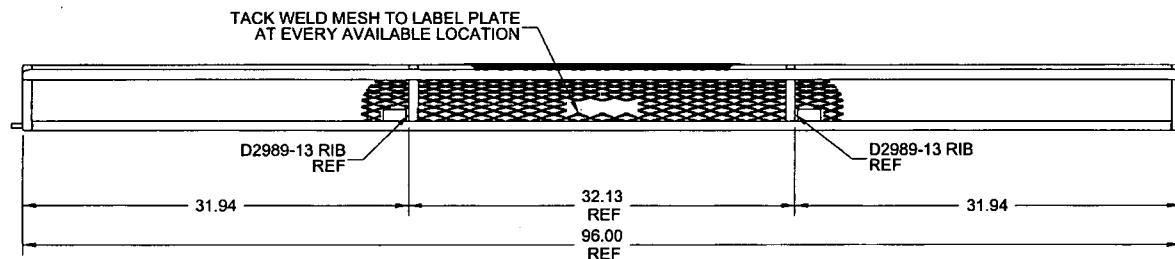
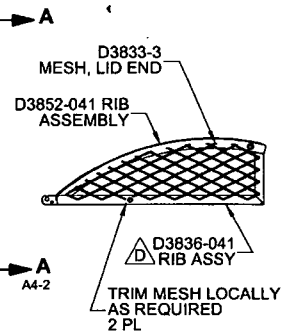
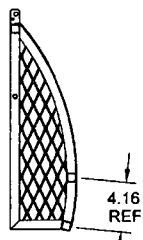
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

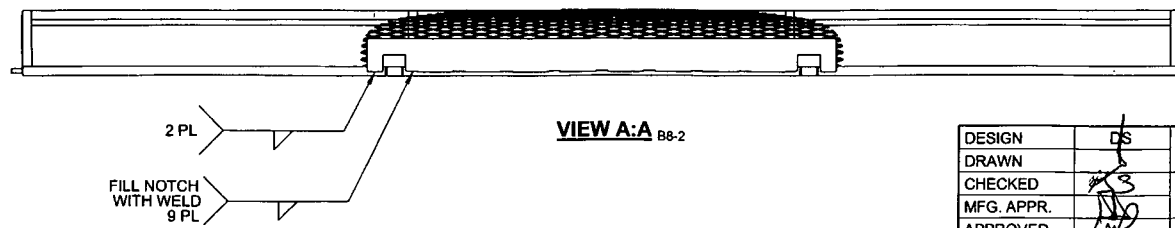


TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D
BLACK ANTI-SKID PAINT THIS SECTION

SECTION B-B
D7-2






D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

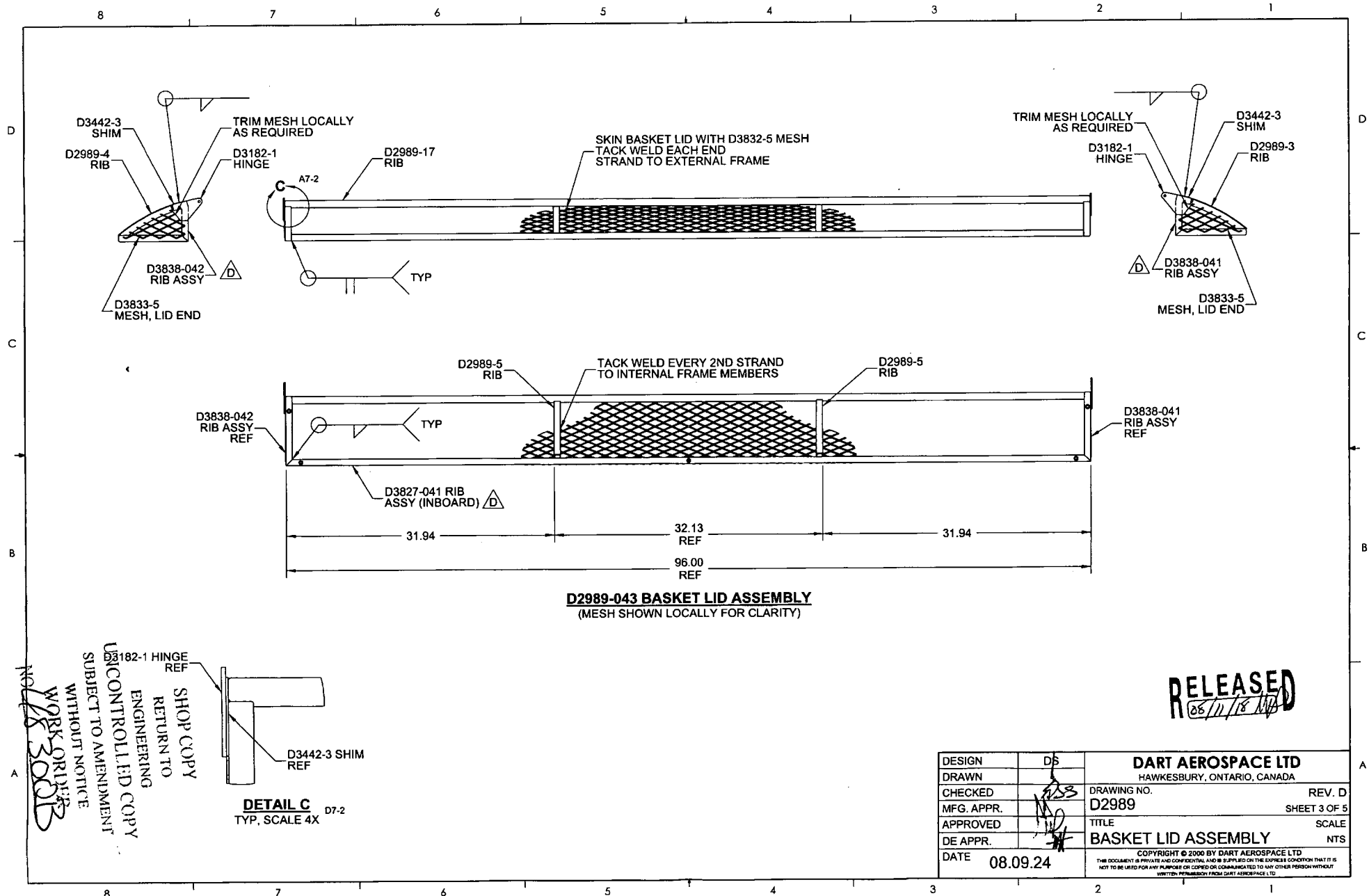


RELEASED
08/11/13

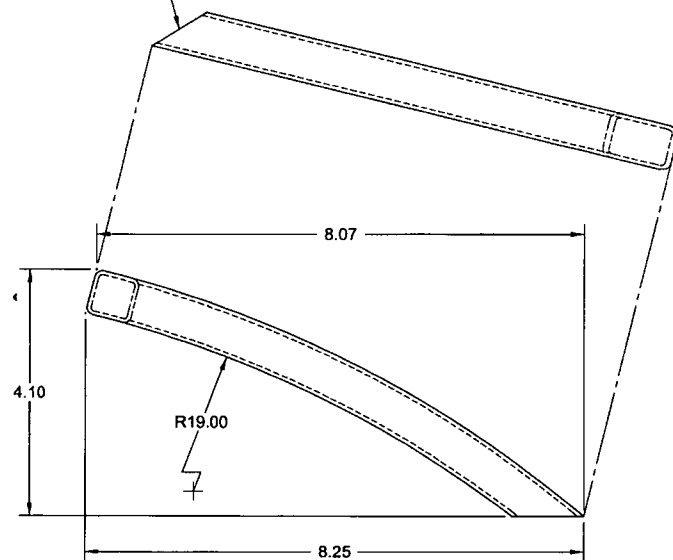
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WORK ORDER
NO 16300B

DESIGN	DS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	
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8 7 6 5 4 3 2 1

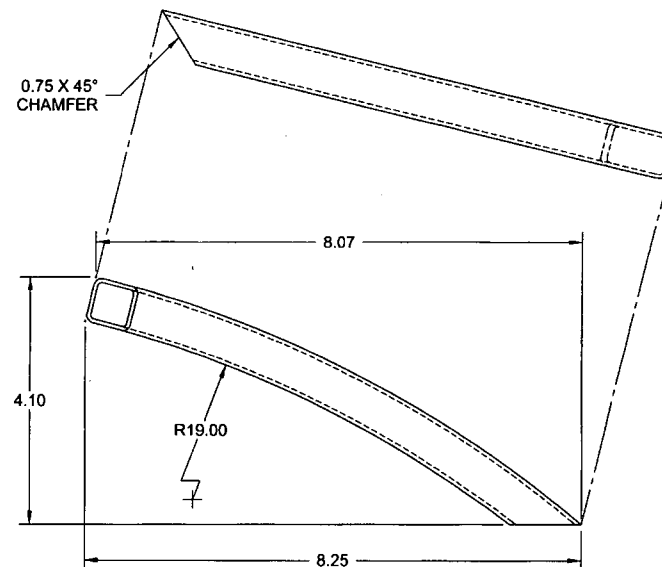


0.75 X 45°
CHAMFER

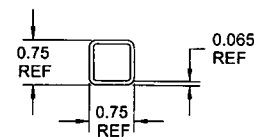


D2989-3 RIB

0.75 X 45°
CHAMFER



D2989-4 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18/19

NOTES:

- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/4 = 0.39 lbs;

NO. 483082
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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